

# GMK 2510 Contact Adhesive



## Strong | permanently elastic | temperature-resistant

GMK 2510 is a 2-component adhesive based on polychloroprene for the full-surface and permanently elastic bonding of parts continuously exposed to dynamic loads. The advantage compared to 1-component contact adhesives is the significantly improved adhesion and higher temperature resistance. GMK 2510 bonds rubber, metal, textiles, leather, sponge rubber (neoprene), CSM (Hypalon), insulating materials, PU materials with an adhesive coating, wood, stones and many plastics. After curing, the joint is resistant to humidity. WEICON GMK 2510 is not suitable for materials such as polystyrene foam, polyethylene, polypropylene parts, PVC soft foam and PVC imitation leather.

### Technical Data

Base	Polychloroprene (CR)
Colour	black
Density	0,85 g/cm <sup>3</sup>
Viscosity	1500 mPa·s
Mixing ratio	100:7
Pot life	at 23 °C, 50 % rel. air humidity > 2 h
Evaporation time	5 - 15 min.
Consumption	150 - 300 g/m <sup>2</sup>
Final strength (100 % strength)	24 h
Processing temperature	+15 to +35
Lap shear strength material thicken. 1,5mm DIN EN 1465	
Galvanized steel	3 N/mm <sup>2</sup>
Galvanised steel + EPDM	0,6 N/mm <sup>2</sup>
Galvanised steel + SBR	0,5 N/mm <sup>2</sup>
Galvanised steel + NBR	0,49 N/mm <sup>2</sup>
Temperature resistance	-40 to +80 for a short period of time (approx. 1 h) to +130 °C
Approvals / Guidelines	
IMPA Code	815239/40
MIL-Spec complies with	MIL-A-21366A

## Surface Pre-Treatment

The parts to be joined must be clean, dry, and free of dust and grease (WEICON Surface Cleaner). Roughening the surfaces effectively increases the strength of the bond.

## Application

Stir the product well before use (GMK 2510 only the adhesive) and then evenly apply a thin layer across the entire bonding surface with a paint brush or spatula (smooth or serrated). Two or three thin layers may be required depending on the type of material and application. Depending on the layer thickness, ambient temperature and air humidity, allow the coated surfaces to evaporate for 5 - 15 minutes. With absorbent surfaces (e.g. felt), an additional adhesive layer should be applied after evaporating. As soon as the surfaces are dry but still feel a bit sticky (finger test), the parts must be joined under brief, strong pressure (e.g. with a roller or hammer). If the evaporation time is exceeded (over-drying), the adhesive must be applied again. Non-cured, exceeding adhesive can be removed with WEICON Surface Cleaner. Mixing procedure for GMK 2510: Mix the adhesive and crosslinking agent for at least 4 minutes thoroughly and without any bubbles (mixing ratio 100:7) with the processing spatula or mechanical mixers at a low speed (max. 500 r/min.) to get a uniform mixture. Only prepare a batch as large as can be processed within the flash-off time.

## Storage

Store in the unopened original container at room temperature. Avoid sources of heat and direct sunlight.

## Instructions for use

When using WEICON products, the physical, safety-related, toxicological and ecological data and regulations in our EC safety data sheets ([www.weicon.com](http://www.weicon.com)) must be observed.

## Accessories

- 10010887 Processing Spatula, 1 PCE
- 10022562 Processing Spatula, 1 PCE
- 10010066 Contour Spatula Flexy, 1 PCE

## Available sizes

- 10034480 GMK 2510 Contact Adhesive, 0,69 kg, black
- 10039649 GMK 2510 Contact Adhesive, 0,32 kg, black

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### Note

The specifications and recommendations given in this technical data sheet must not be seen as guaranteed product characteristics. They are based on our laboratory tests and on practical experience. Since individual application conditions are beyond our knowledge, control and responsibility, this information is provided without any obligation. We do guarantee the continuously high quality of our products. However, own adequate laboratory and practical tests to find out if the product in question meets the requested properties are recommended. A claim cannot be derived from them. The user bears the only responsibility for non-appropriate or other than specified applications.

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